

Work Order ID 66307

February 9, 2011 3:45:53 PM



Page 1

Item ID: D4273-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly, RH

Start Date: 2/09/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/17/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 11-02-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4273	<i>C D</i>								
D4279	B								

100

Large Fab

Weld per dwg A/R S.S. rod Batch: *115928* 0.00
Large Fab

Memo 0.00

1- assemble ribs and handle plates (DO NOT WELD HANDLE IN SECTION N-N ON PAGE 7 DWG D4273, NEED TO WELDED AFTHET MESH IS INSTALL) weld as per dwg D4273 using DT9610A

visual inspect before welding mesh

2- Cut D4279-1 base mesh and all tack weld mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

110

QC
Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo 0.00

Pl 11.03.01

11.03.01 11.03.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

Item ID: D4273-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly, RH

Start Date: 2/09/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/17/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

*- inspected to Rev D
Dwg's only**2/03/01**(X)*

125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

0.00

(IX) m.d. 11/03/01

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Accept

**Setup Start**

Stop

**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start



Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____



**Insp.
Stamp**

0.00



Powdercoat

Powder Coating

Memo

1- Plug holes and mask only interior of hinge (3) prior to powder coat

0.00

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*****2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE: _____

FINISH TIME:

140

00000000000000000000000000000000

OC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

(17) m.p 11/03/01

1 of 11/03/01

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Revision ID: Stop 
Item Name: Basket Base Assembly, RH
Start Date: 2/09/11 Start Qty: 1.00  Cust Item ID:
Required Date: 2/17/11 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging	Identify as per dwg & Stock Location: <i>GA</i>	0.00							
Packaging	Memo <i>w/p 66305</i>	0.00							<i>EBH/03/02 (1)</i>
160  QC	QC21- Final Inspection - Work Order Release	0.00							<i>W/03/03</i>
Quality Control	Memo	0.00							<i>UMP</i> <i>11-03-03</i>

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 66307

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 2/09/11

Required Date: 2/17/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.16 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ M304EX0.75-16F

Purchased

No

100

sf

983.8489

26.195

26.195



Expanded Metal Flat SS



SAD 11-02-25

Location

Loc Qty

Loc Code

MAT

983.848933

114809

78.622943

114853

11.80059

115012

243.963

115401

46.8795

115989

46.5313

116178

3.0206

116508

33.3012

116768

199.7298

116795

320

26.195

✓ D3913-1

Manufactured

No

100

Each

2.0000

1



Rib



1
Pl 11.03.01

Location

Loc Qty

Loc Code

WA

2

64467

2

①

✓ D3913-3

Manufactured

No

100

Each

6.0000

1



Rib



1
Pl 11.03.01

Location

Loc Qty

Loc Code

WA

6

65314

3

①

65852

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 66307

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 2/09/11

Required Date: 2/17/11

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-9

Manufactured No

100 Each

3.0000

1

1



Hinge Rib



Cpl 11-03-01

Location

Loc Qty

Loc Code

WA

3

65315

3

✓ D3916-5

Manufactured No

100 Each

10.0000

3

3



Light Rib



Cpl 11-03-01

Location

Loc Qty

Loc Code

WA

10

57023

1

65429

9

✓ D4017-7

Manufactured No

100 Each

4.0000

1

1



Rib



Cpl 11-03-01

Location

Loc Qty

Loc Code

WA

4

58929

2

65850

2

✓ D4277-3

Manufactured No

100 Each

2.0000

1

1



Rib



360091 → ①
Cpl 11-03-01

Location

Loc Qty

Loc Code

WA

2

63759

1

65684

1

①

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 4

Work Order ID: 66307

Parent Item: D4273-042




Parent Item Name: Basket Base Assembly, RH

Start Date: 2/09/11

Required Date: 2/17/11

Start Qty: 1.00

Required Qty: 1.00

✓ D4306-1	Manufactured	No	100	Each	0.0000	1	1		B66311 → ① Pl 11.03.01
Rib									
✓ D4306-044	Manufactured	No	100	Each	1.0000	1	1		 Pl 11.03.01
Rib Assembly, RH									

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 66307

Parent Item: D4273-042

Parent Item Name: Basket Base Assembly, RH

Start Date: 2/09/11

Required Date: 2/17/11

Start Qty: 1.00

Required Qty: 1.00

✓ D4016-1
Hinge Half, Base

Manufactured No

100 Each

1.0000

3

3

Location

Loc Qty

Loc Code

WA

1

65374

1

100 Each

16.0000

3

3

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

11

65848

11

✓ D4021-1
Handle Plate

Manufactured No

100 Each

16.0000

3

3

Location

Loc Qty

Loc Code

ST109

5

57086

5

WA

11

65848

11

✓ D4279-3
Mesh, Chamfer

Manufactured No

100 Each

2.0000

1

1

Location

Loc Qty

Loc Code

WA

2

65694

2

✓ D4279-5
End Mesh, Basket

Manufactured No

100 Each

1.0000

1

1

Location

Loc Qty

Loc Code

WA

1

65695

1

Ppl 11-03-01
B66334 → ②
B65849 → ①

Ppl 11-03-01

③
1
Ppl 11-03-01

①
Ppl 11-03-01

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 66307

Parent Item: D4273-042







Parent Item Name: Basket Base Assembly, RH

Start Date: 2/09/11

Required Date: 2/17/11

Start Qty: 1.00

Required Qty: 1.00

✓ D4279-7	Manufactured	No	100	Each	2.0000	2	2		<u>P/L 11-03-01</u>												
																					
End Mesh, Basket																					
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>WA</td><td>2</td><td></td></tr><tr><td>65696</td><td>2</td><td></td></tr></table>										<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	WA	2		65696	2				
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																			
WA	2																				
65696	2																				
✓ D4279-9	Manufactured	No	100	Each	2.0000	1	②		<u>P/L 11-03-09</u>												
							②														
End Mesh, Basket																					
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>WA</td><td>2</td><td></td></tr><tr><td>63790</td><td>1</td><td></td></tr><tr><td>65697</td><td>1</td><td></td></tr></table>										<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	WA	2		63790	1		65697	1	
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																			
WA	2																				
63790	1																				
65697	1																				
✓ D4279-11	Manufactured	No	100	Each	1.0000	1	①		<u>P/L 11-03-01</u>												
							①														
Mesh, Base																					
<table><tr><th><u>Location</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td>WA</td><td>1</td><td></td></tr><tr><td>65698</td><td>1</td><td></td></tr></table>										<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	WA	1		65698	1				
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>																			
WA	1																				
65698	1																				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

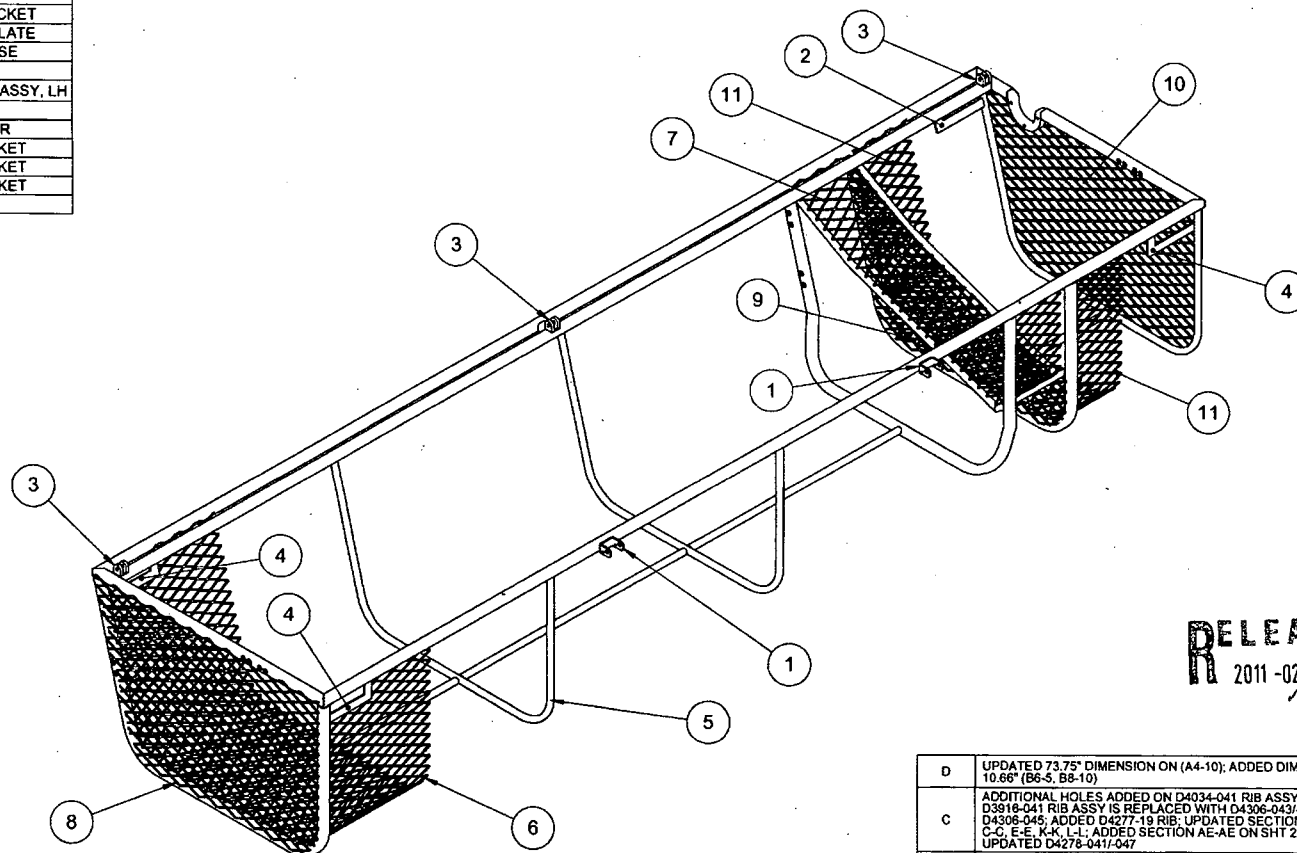
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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-041	BASKET BASE ASSY, LH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-141	BASKET FRAME ASSY, LH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE



D4273-041 BASKET BASE ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

RELEASED
R 2011-02-24

D	UPDATED 73.75" DIMENSION ON (A4-10); ADDED DIM 10.66" (B6-5, B8-10)	SC	11.02.09
C	ADDITIONAL HOLES ADDED ON D4034-041 RIB ASSY: D3918-041 RIB ASSY IS REPLACED WITH D4306-043/044 & D4306-045; ADDED D4277-19 RIB; UPDATED SECTION B-B, C-C, E-E, K-K, L-L; ADDED SECTION AE-AE ON SHT 2; UPDATED D4278-041/047	SC	10.12.23
B	REDESIGN: ADD (1) D4021-1, (1) D4279-7, (1) D4279-11 (D6-1, D6-8); RMV D4277-17, D4278-043 (SHT 4.9); ADD (1) D3918-1, (2) D4277-5, (1) D4277-9, (1) D4306-1 (D6-4, D6-9), RMV (1) D4277-3 (D6-4, D6-9); 24.25 WAS 20.25 (A5-5, A5-10)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4273** REV. D
SHEET 1 OF 10

TITLE **BASKET BASE ASSY** SCALE NTS

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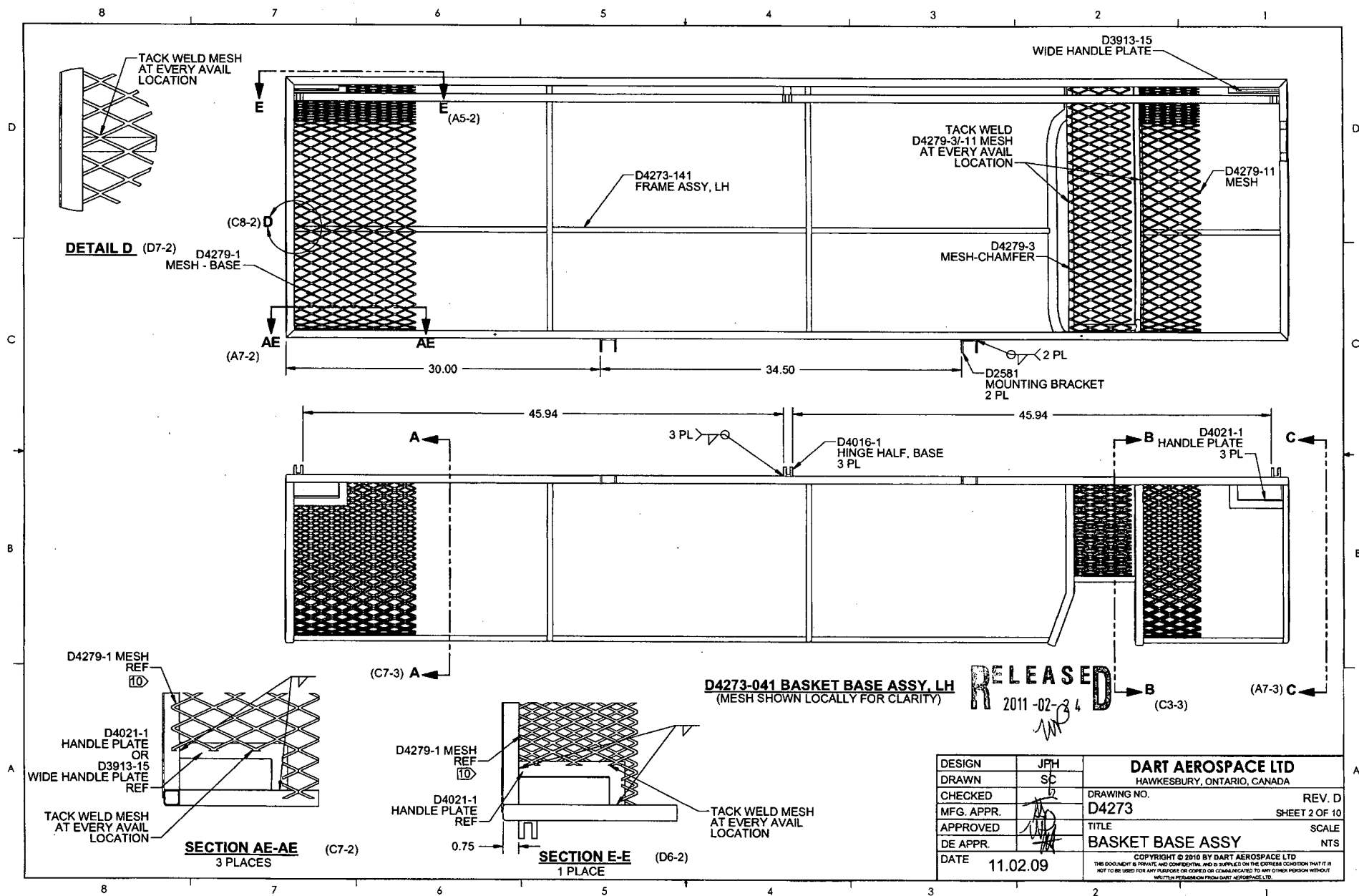
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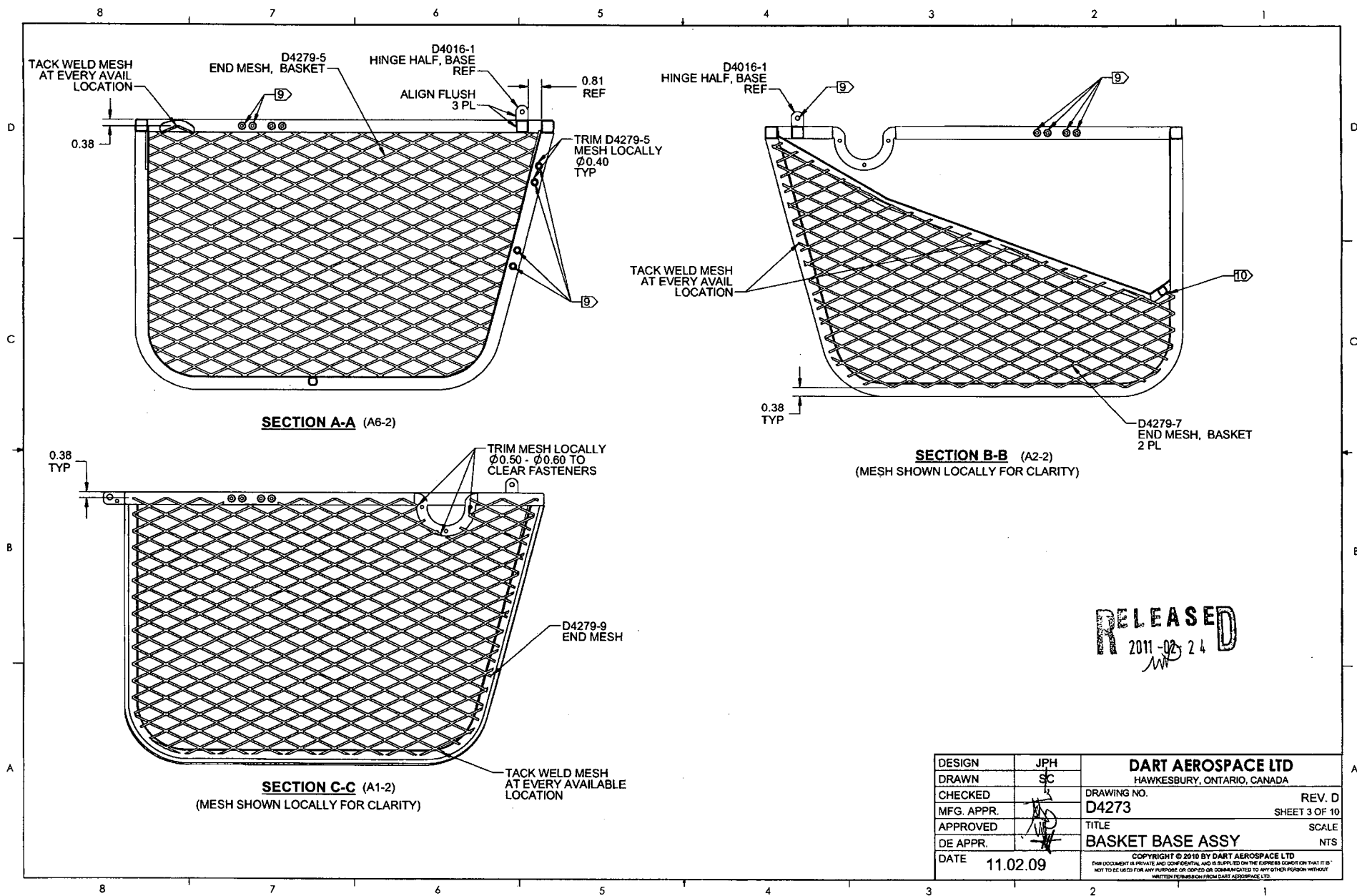
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RELEASED
2011-02-24

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 3 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	11.02.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

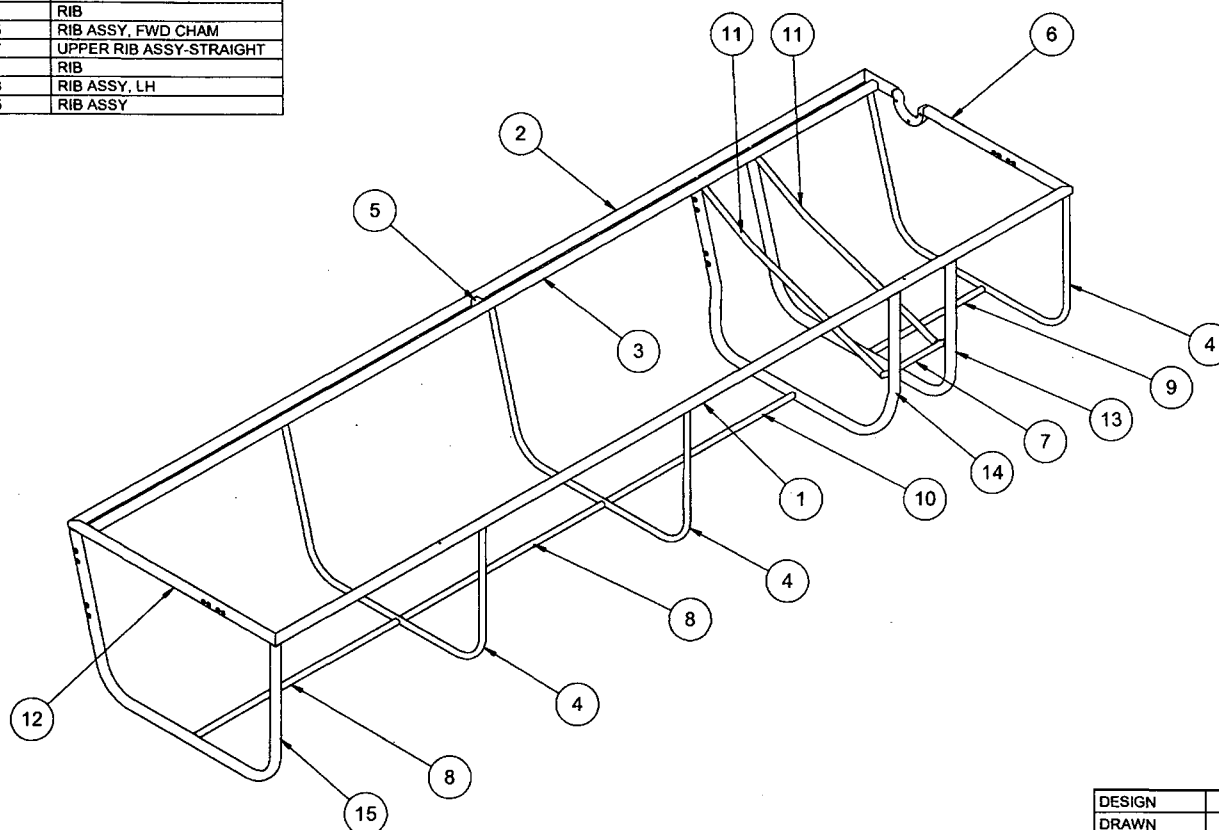
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NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-141	BASKET FRAME ASSY, LH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4034-041	AFT UPPER RIB ASSY
7	1	D4277-3	RIB
8	2	D4277-5	RIB
9	1	D4277-9	RIB
10	1	D4277-19	RIB
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-043	RIB ASSY, LH
15	1	D4306-045	RIB ASSY



D4273-141 FRAME ASSY, LH

RELEASED
2011-02-24
M/D

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 4 OF 10
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSY	NTS
DATE	11.02.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

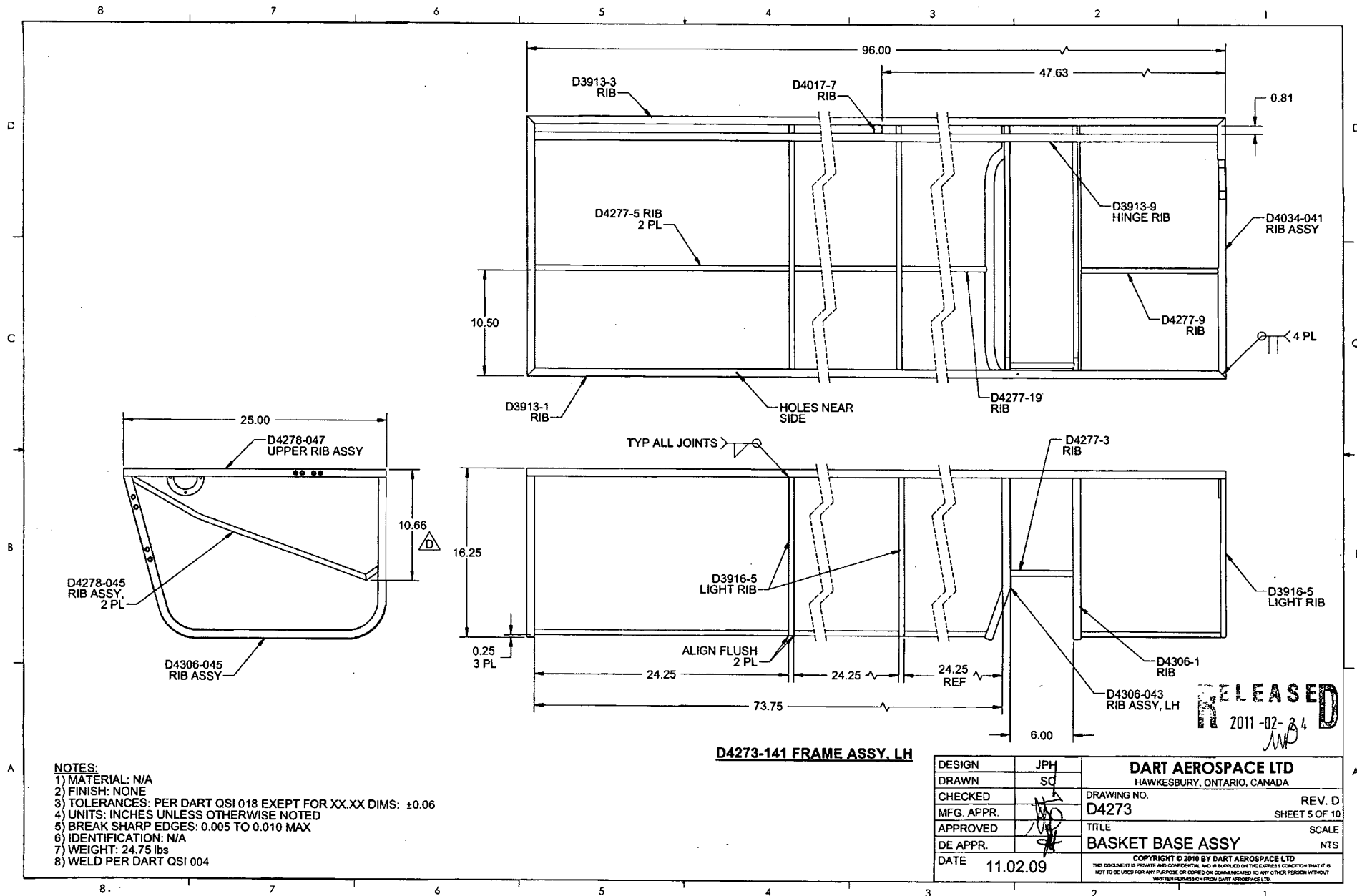
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

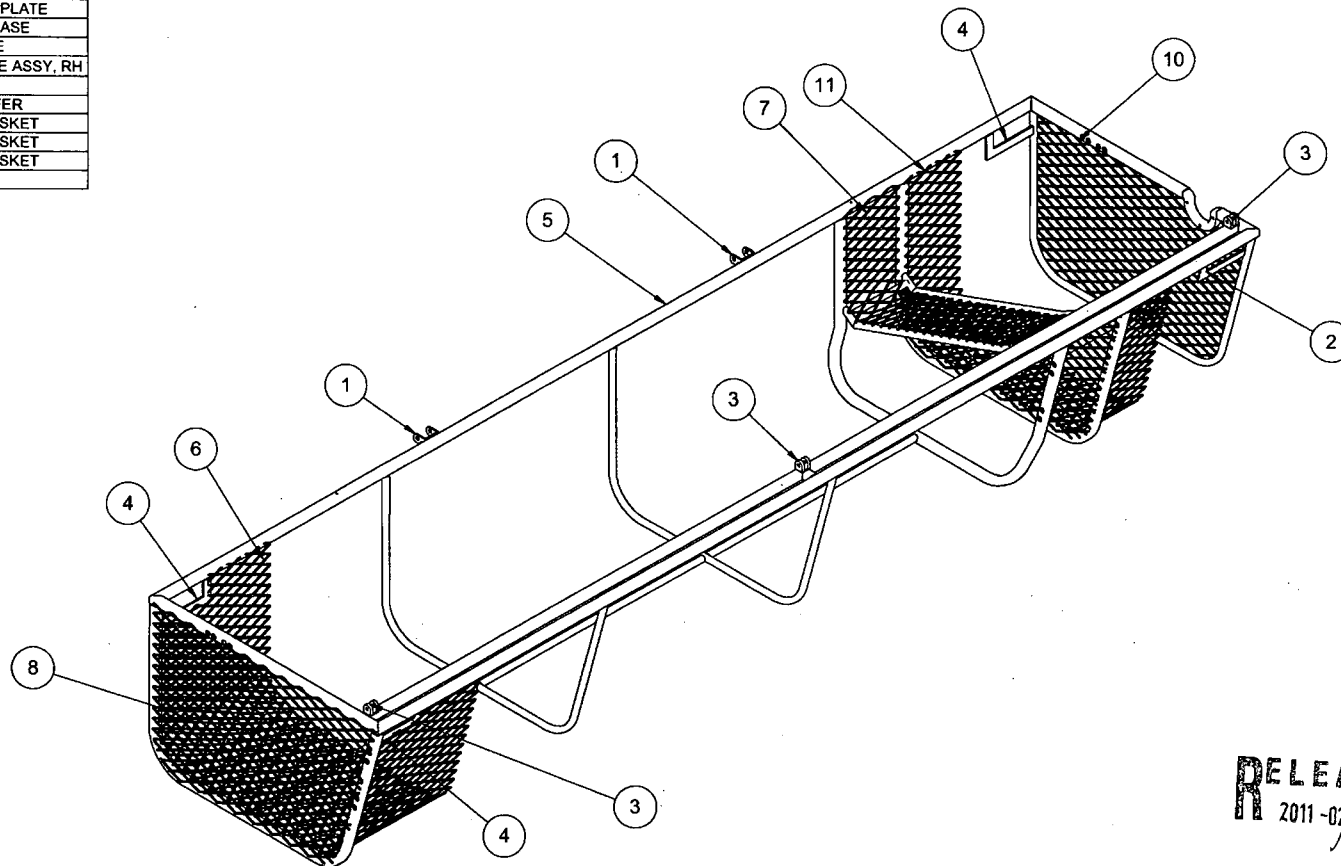
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-042	BASKET BASE ASSY, RH
1	2	D2581	MOUNTING BRACKET
2	1	D3913-15	WIDE HANDLE PLATE
3	3	D4016-1	HINGE HALF, BASE
4	3	D4021-1	HANDLE PLATE
5	1	D4273-142	BASKET FRAME ASSY, RH
6	1	D4279-1	MESH - BASE
7	1	D4279-3	MESH - CHAMFER
8	1	D4279-5	END MESH, BASKET
9	2	D4279-7	END MESH, BASKET
10	1	D4279-9	END MESH, BASKET
11	1	D4279-11	MESH - BASE



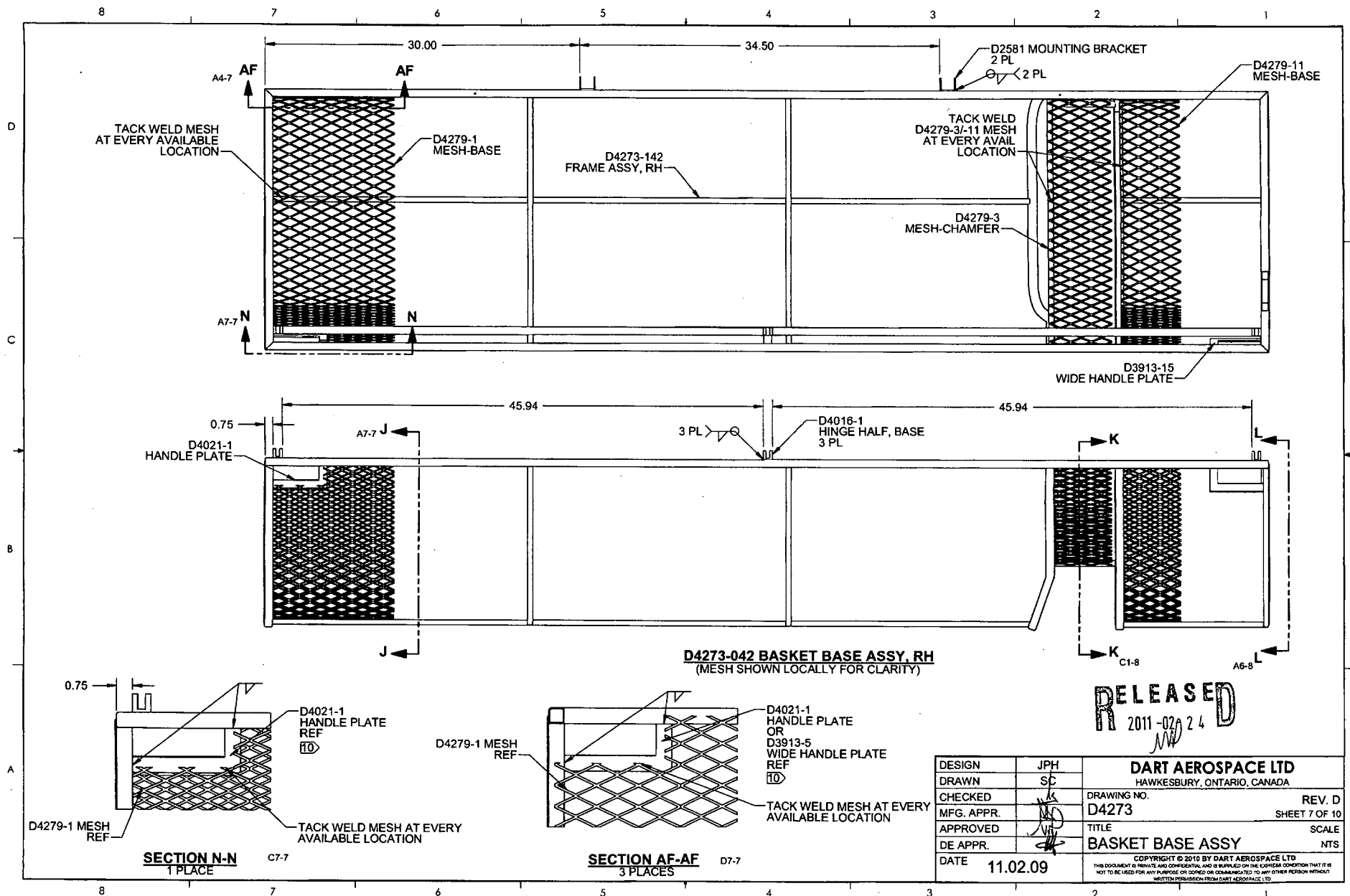
D4273-042 BASKET BASE ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

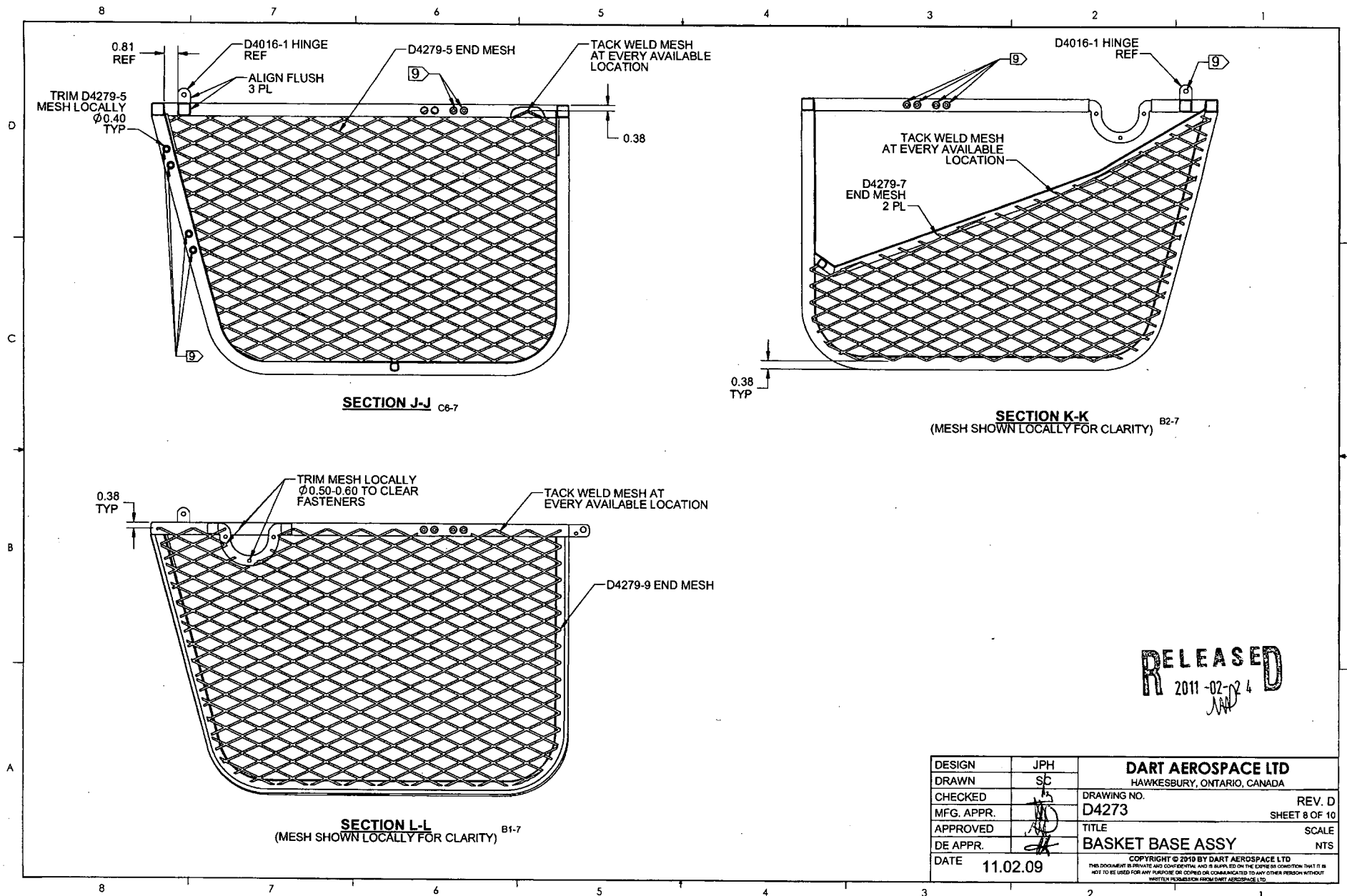
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 45 lbs APPROX
- 8) WELD PER DART QSI 004
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) TRIM AS NECESSARY TO CLEAR FASTENERS/STRUCTURE.

RELEASED
2011-02-24
MD

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	ND	DRAWING NO.	REV. D
MFG. APPR.	ND	D4273	SHEET 6 OF 10
APPROVED	ND	TITLE	SCALE
DE APPR.	ND	BASKET BASE ASSY	NTS
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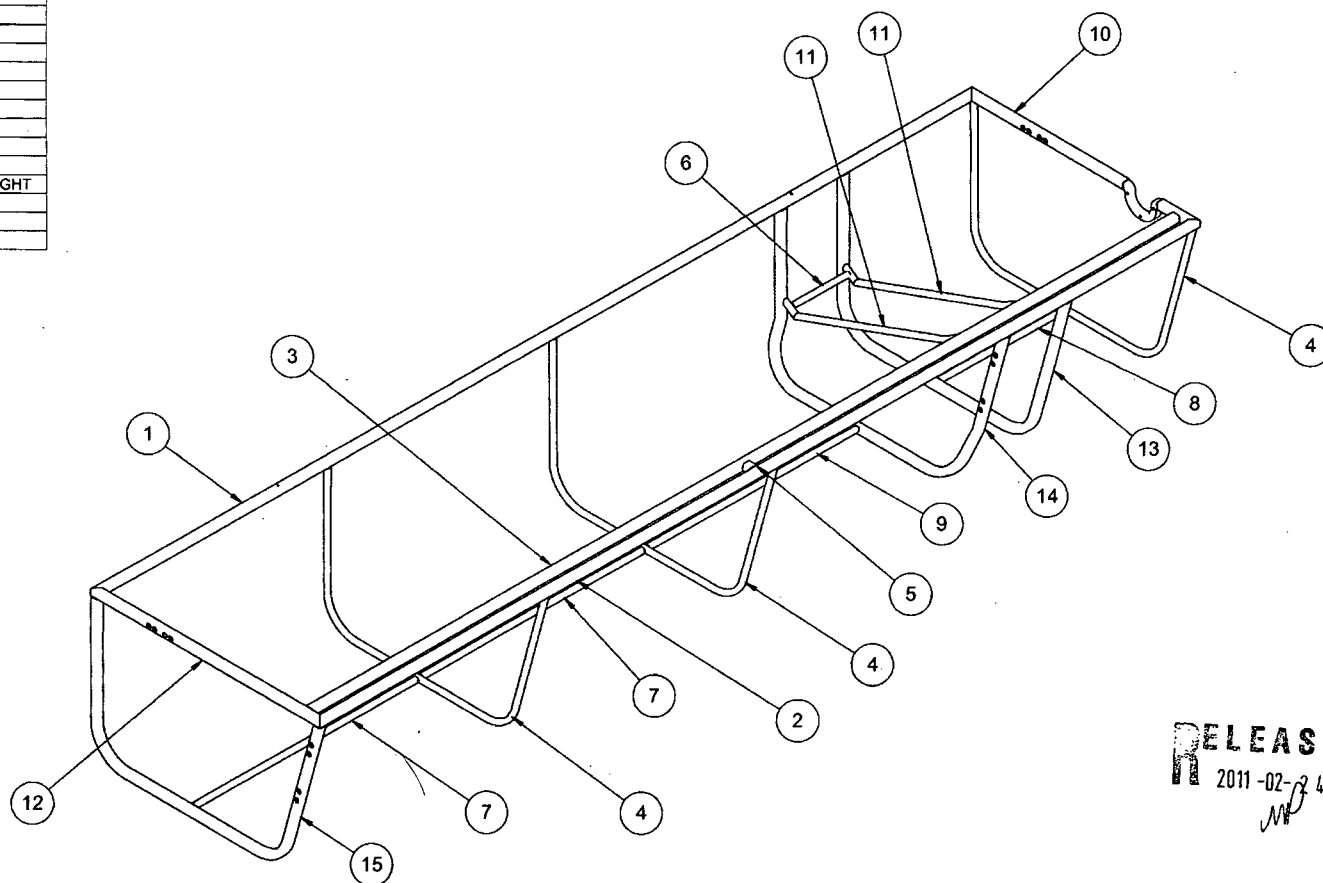




RELEASED
2011-02-24

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4273	SHEET 8 OF 10
APPROVED		TITLE	SCALE
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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4273-142	BASKET FRAME ASSY, RH
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	1	D3913-9	HINGE RIB
4	3	D3916-5	LIGHT RIB
5	1	D4017-7	RIB
6	1	D4277-3	RIB
7	2	D4277-5	RIB
8	1	D4277-9	RIB
9	1	D4277-19	RIB
10	1	D4278-041	UPPER RIB ASSY-HOOP
11	2	D4278-045	RIB ASSY, FWD CHAM
12	1	D4278-047	UPPER RIB ASSY-STRAIGHT
13	1	D4306-1	RIB
14	1	D4306-044	RIB ASSY, RH
15	1	D4306-045	RIB ASSY



D4273-142 BASKET FRAME ASSY, RH

RELEASED
2011-02-24
M

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D4273	SHEET 9 OF 10
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	BASKET BASE ASSY	NTS
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